

# DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 1 of 4

## PAINT: "Dark Grey"

DSF291

### TYPE

1. SENOTEX Two Pack Dark Grey (Suede Finish) Non-Anti Static
2. SENOTEX HARDENER (Ref :19-0306-501.105) Mixing Ratio 10:1 Paint : Hardener
3. SENOTEX THINNER (Ref : 00-9777-501.033) (Use as required)

### PAINT PRIMERS:

1. SENOPUR Primer One coat, Two Pack Black Ref : 03-0377-500.727  
(Note : Primer is only to be used on metal surfaces.)

### MANUFACTURER

SENOTEX

### REFERENCE

See Type above

### PREPARATION :

#### GRP MATERIAL :

(No Primer Required)

- 1 The smooth surface of the GRP material must be sanded to give a surface roughness of 320 grip/square inch using Dry Production abrasive paper. This is to provide a key for the paint.
- 2 ANTISTATIC CLEANER J131  
Before attempting to apply a finishing system to a plastic substrate, the surface must be thoroughly clean and free from contaminants. Antistatic Cleaner J131 effectively cleans the surface and removes release agents without attacking sensitive plastics. It can also reduce surface static, a magnet for dust which could mar the appearance of the finish.

### AVAILABILITY

Full details of the container sizes and prices may be obtained from TRIMITE sales offices.

### FLASH POINT

Flash point below 21°C. Tested to BS 3900 Part A8

### STORAGE

The recommended temperature range for storage is between 10°C - 15°C. It is not considered advisable to store this material outside this temperature range or to exceed a storage period of twelve months prior to use.

| Issue | 01   | 02 | 03 | 04 | 05 | 06 | 07 | 08 |
|-------|------|----|----|----|----|----|----|----|
| DCR   | 7135 |    |    |    |    |    |    |    |

# DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 2 of 4

**PAINT: "Dark Grey"**

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## APPLICATION

Using a brush or clean cloth. Antistatic Cleaner J131 should be applied liberally to the substrate. It is important to change the cloth regularly to avoid returning contaminants to the surfaces. Clean gloves should be worn when handling surfaces which have been treated.

## SAFETY

This product is not formulated as a skin cleaning material nor should it be used for cleaning clothing or any protective equipment. Do not use on electrical equipment or cables.

Before use, refer to :   1. TRIMITE Good Housekeeping Guide.  
                                  2. TRIMITE Individual Safety Info. Sheet.

## STEEL / ALUMINIUM

- 1     The substrate must be thoroughly clean and free from contamination, corrosion and grease. Conventional degreasing methods may be employed, but for maximum efficiency, degreasing with Trimite Vapour Degreasing Solvent M6052 (Genklene LV) is recommended.
- 2     Apply SENOPUR Primer One Coat Two Pack Black     Ref : 03-0377-500.727

## TECHNICAL INFORMATION

Colour :                       Black  
Gloss :                       Matt  
Supply viscosity :         50-60 sec DIN 53211/4mm//20°C  
Weight solids :            Approx. 44 +/- 2%  
Volume solids :            Approx. 33 +/- 2%  
SG wet :                    Approx. 1.04 g/cm<sup>3</sup>  
SG dry :                    Approx. 1.41 g/cm<sup>3</sup>  
Film thickness wet :       40-50 microns  
Film thickness dry :       20-25 microns  
Theoretical coverage :    Approx. 16 sq. metres per litre at 20 microns  
Shelf life :                6 months in original sealed containers stored at (20-25°C)  
Flash Point :

| Issue | 01   | 02 | 03 | 04 | 05 | 06 | 07 | 08 |
|-------|------|----|----|----|----|----|----|----|
| DCR   | 7135 |    |    |    |    |    |    |    |

## PAINT: "Dark Grey"

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### APPLICATION INSTRUCTIONS

Substrate : Steel, Aluminium, Aluminised Steel, Galvanised Steel.  
Pre-treatment : Degrease.  
Application method : Conventional hand or Automatic Spray. .  
Recommended coating : Two Pack polyurethane coatings  
series system 0345, 0340, 4205 & 4283.  
Hardener : 19-0306-501.105  
Mixing ratio : 100 : 5 by weight. (Paint: Hardener) 20 : 1 by volume  
Thinner : 00-9951-501-033  
Application viscosity : 20 +/- 2 seconds Din 4/20°C  
Pot life : Approx. 4 hours.  
Flash off : 3 - 5 minutes at room temperature.  
Curing schedule : 30 minutes @ 60°C object temperature.  
20 minutes @ 80°C object temperature.  
10 minutes @ 120°C object temperature.

| Issue | 01   | 02 | 03 | 04 | 05 | 06 | 07 | 08 |
|-------|------|----|----|----|----|----|----|----|
| DCR   | 7135 |    |    |    |    |    |    |    |

# DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 4 of 4

## PAINT: "Dark Grey"

DSF291

### TOPCOAT

SENOTEX SUEDE  
SENOTEX HARDENER  
SENOTEX THINNER

Available from : WEILBURGER.

### TECHNICAL INFORMATION :

Colour : Grey  
Gloss : Matt  
Supply viscosity : 40 +/-3 sec DIN 4/20°C  
Weight solids : Approx. 44%  
Volume solids : Approx. 39%  
SG wet : Approx. 0.98  
SG dry : Approx. 1.10  
Film thickness wet : 170 +/- 10 microns  
Film thickness dry : 75 +/- 5 microns  
Theoretical coverage : Approx. 5 sq. metres per litre at 75 microns pre-mixed.  
Shelf life : 6 months from date of despatch in the original unopened containers.  
Flash Point : Below 21°C

### APPLICATION INSTRUCTIONS

Substrate : ABS, PC.  
Pre-treatment : Degrease.  
Application method : Conventional hand or Automatic Spray. Two pack metering apparatus is recommended.  
Recommended coating : One Coat.  
system.  
Hardener : 19-0306-501.105  
Mixing ratio : 100:10:18 by weight.  
Paint:Hardner:Thinner  
Thinner : 00-9777-501-033  
Application viscosity : 20 / DIN 4 / 20°C  
Pot life : 4 hours.  
Flash off : 3 - 5 minutes at room temperature.  
Curing schedule : 30 minutes @ 60°C object temperature.  
20 minutes @ 80°C object temperature.

| Issue | 01   | 02 | 03 | 04 | 05 | 06 | 07 | 08 |
|-------|------|----|----|----|----|----|----|----|
| DCR   | 7135 |    |    |    |    |    |    |    |